

ABSTRACT

The invention provides a method of co-injection molding. The method includes mixing a plastic inner material and an endothermic-blowing agent to form a core mixture. A plastic outer material is injected from a first injection unit into a co-injection manifold to create a flow of outer material therethrough. The core mixture is injected from a second injection unit into the co-injection manifold to create a flow of core mixture therethrough. The flow of the outer material and the flow of the core mixture are then controlled through the co-injection manifold and into a mold cavity. The core mixture expands as heat is provided for the endothermic-blowing agent to absorb.

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